

Work Order ID 58683

Friday, May 14, 2010 11:51:14 AM



Page 1

Item ID: D3536-35

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 5/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 5/20/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-5-14 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3536

☐ Dwg Rev:

A

☐ Prog Rev:

A

☐ 2-

Deburr if necessary

B10-5-20

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-5-20

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulstar

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58683

Friday, May 14, 2010 11:51:14 AM



Page 2

Item ID: D3536-35

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 5/14/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 5/20/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>FP12</u> Memo	0.00 0.00				<u>10-5-01</u>		<u>51</u>	<u>(120)</u>
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/05/25</u> <u>MF</u> <u>10-5-20</u>

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 14, 2010 11:51:19 AM

Page 1

Work Order ID: 58683



Parent Item: D3536-35



Parent Item Name: Gasket

Start Date: 5/14/2010

Required Date: 5/20/2010

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	139.2531	0.6197	7.7.		



NEOPRENE SHEET 0.063



1310-5-20

Location

Loc Qty

Loc Code

MAT052

139.2531

114176

139.2531

114691

114691

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58683
Description: Gasket		Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	✓			
19.75	+/-0.030	19.25	✗			
17.75	+/-0.030	17.25	✗			
14.25	+/-0.030	14.25	✗			
9.50	+/-0.030	9.50	✓			
4.75	+/-0.030	4.75	✓			
2.00	+/-0.030	2.001	✓			
6.00	+/-0.030	6.000	✓			
6.75	+/-0.030	6.750	✗			
0.30	+/-0.030	.304	✓			
0.30	+/-0.030	.303	✓			
1.89	+/-0.030	1.888	✓			
Ø0.19	+0.005/-0.001	.191	✓			
0.063	+/-0.010	.062	✗			

Measured by: <u>B</u> Date: <u>10-5-20</u>	Audited by: <u>S</u> Date: <u>10/5/20</u>	Prototype Approval: N/A Date: N/A
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Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM <u> </u>	<u> </u>

W/O:		WORK ORDER CHANGES					
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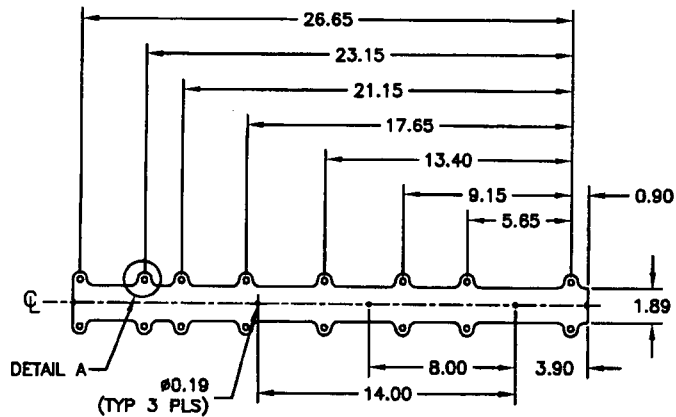
NOTE: Date & initial all entries

DART

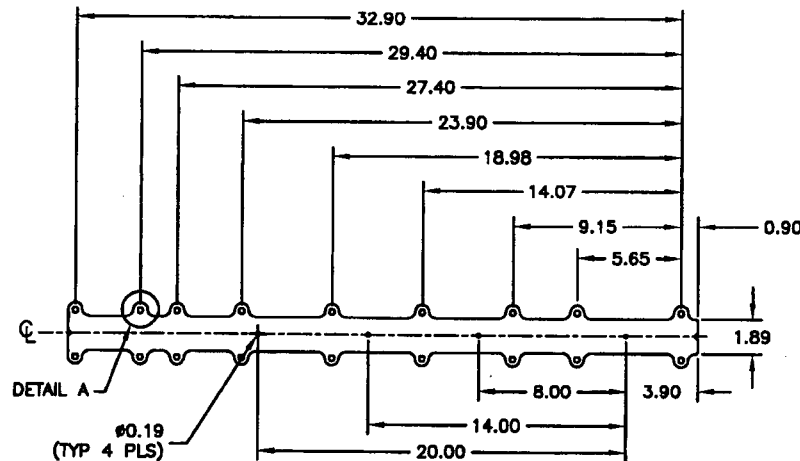
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CB	CB	PORT HADLOCK, WA	
CHECKED AH	APPROVED [Signature]	DRAWING NO. D3536	SHEET 1 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED
09.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58683
1310-5-14



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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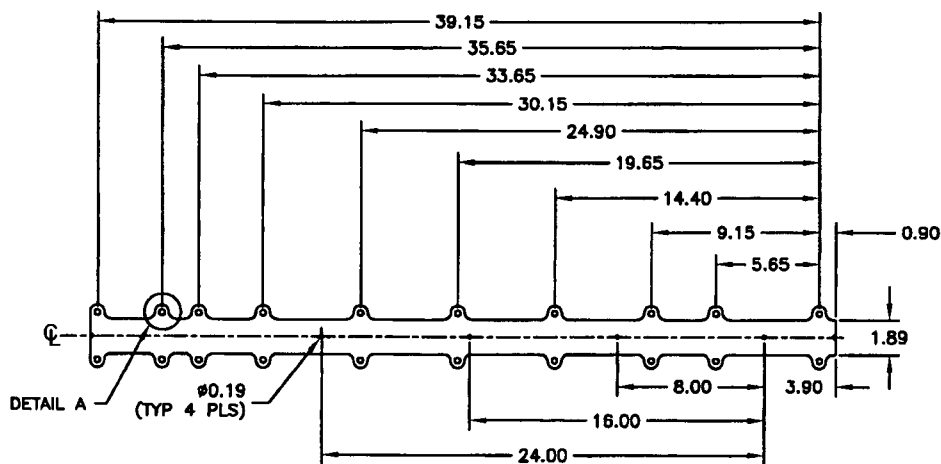
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

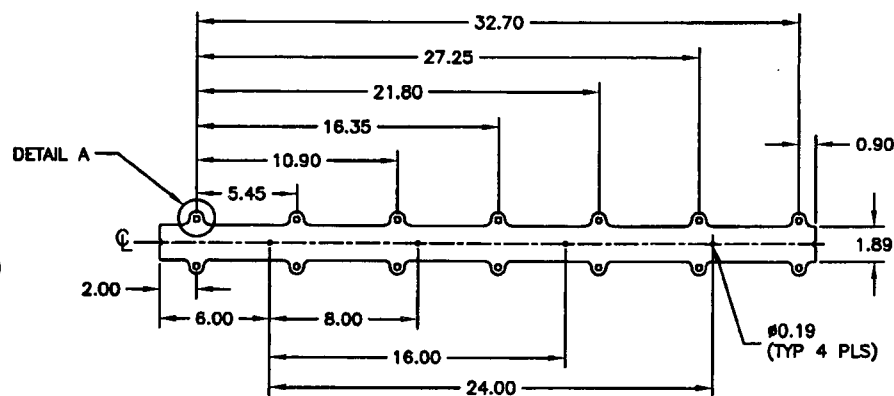
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 2 OF 6
				SCALE 1:10

RELEASED
070212



D3536-15 GASKET

W10 58683



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

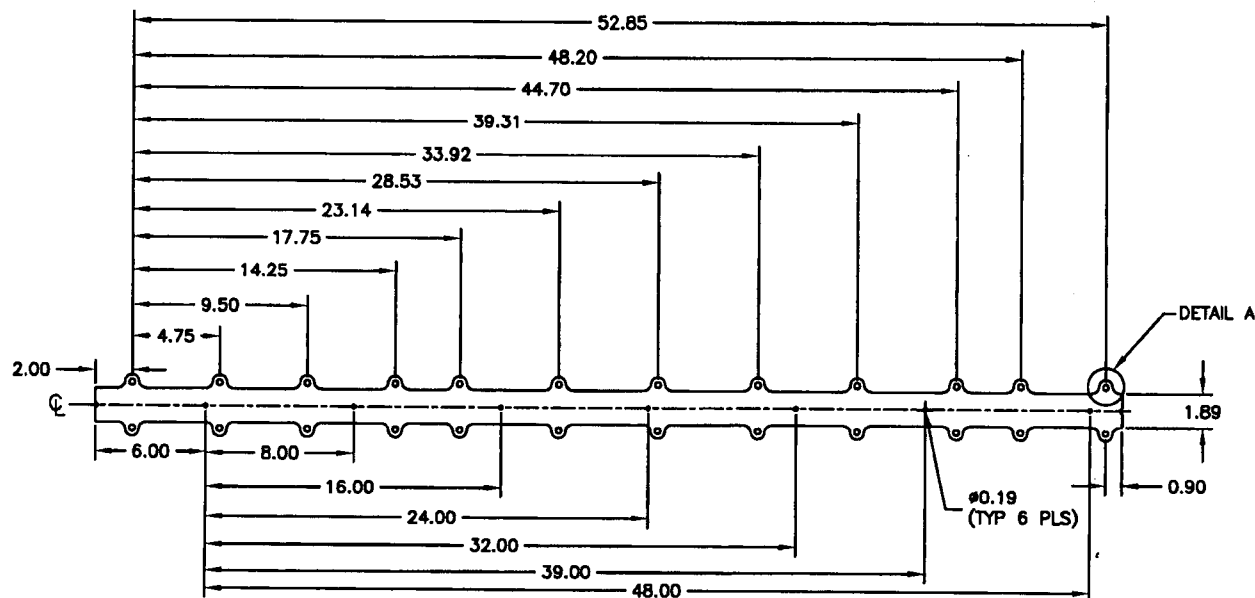
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

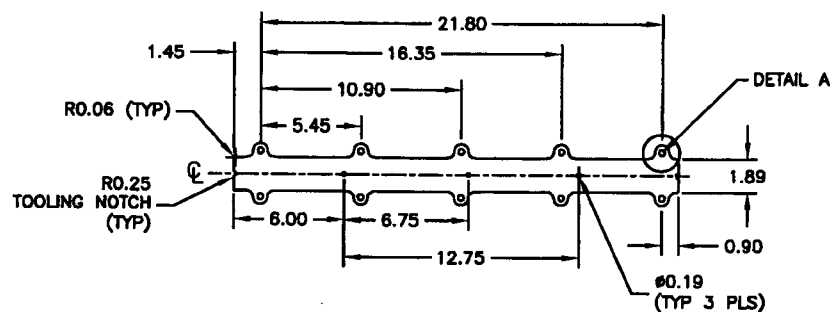
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CHECKED PH	APPROVED PH	PORT HADLOCK, WA	
DATE 06.10.25	DRAWING NO. D3536	TITLE GASKET	SHEET 3 OF 6
		SCALE 1:10	

RELEASED
070212



D3536-23 GASKET

w/o 58683



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

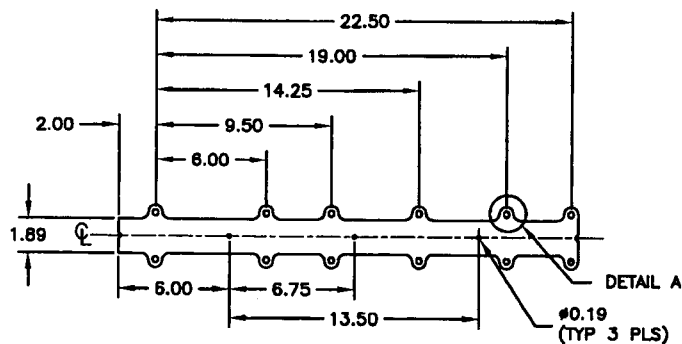
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NOTE: Date & initial all entries

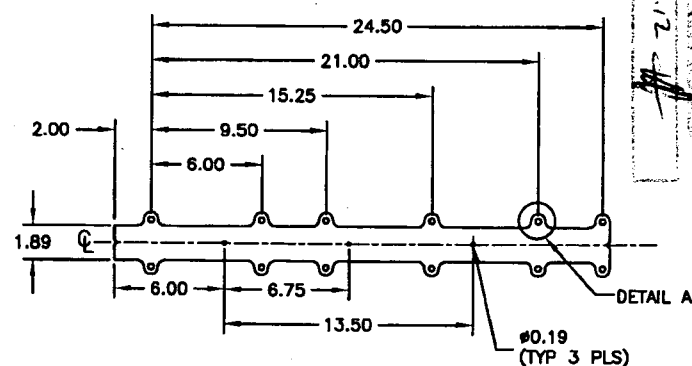
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 4 OF 6
		SCALE	1:10	

07.02.12

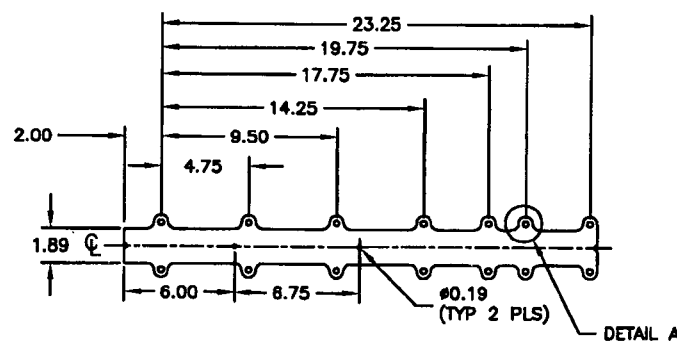


D3536-31 GASKET



D3536-33 GASKET

W/0 58683



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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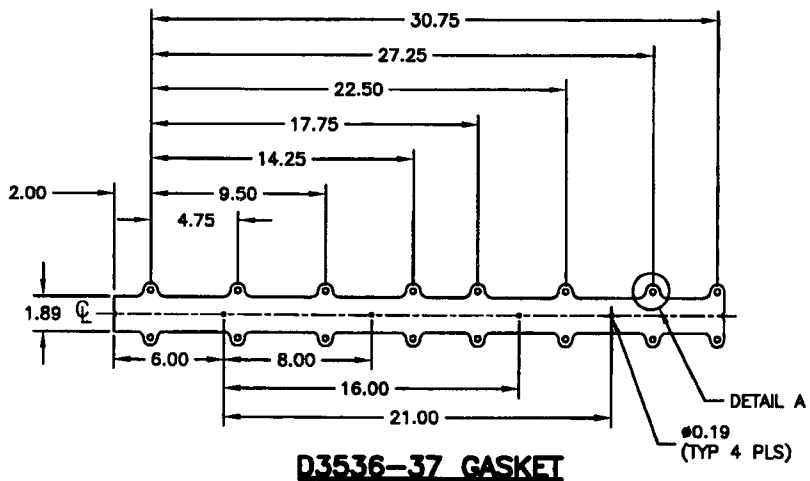
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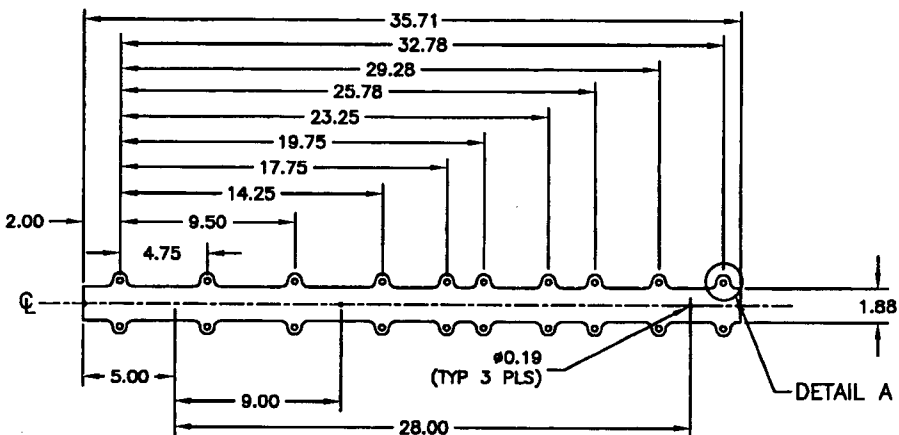
DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10



D3536-37 GASKET

W/O 58483



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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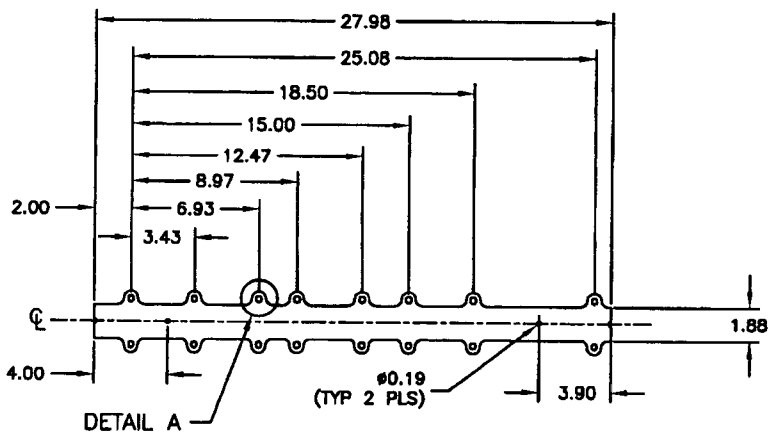
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DART

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 6 OF 6
		SCALE	1:10	

REWORKED
07.02.12



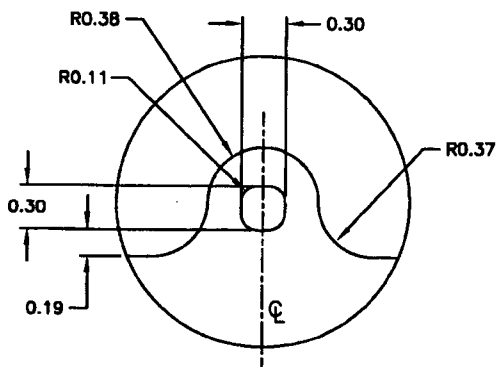
D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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WLO 58683

DETAIL A



W/O:		WORK ORDER CHANGES					
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